

Work Order ID 74476

Monday, October 03, 2011 9:44:59 AM



Page 1

Item ID: D2661-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 9/30/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: H.L.J.Date: 11/10/03 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2661

Rev D

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

22 11. 10. 2710

HAAS CNC vertical machine #1

Program part number and batch number. ☐ Fixturing Inspection last completed
11.10.27 by WSP ☐ 1-Machine Step No 1 of Folio and visually inspect as
per attached Dimension Sheet ☐ 2-Machine Step No 2 of Folio and visually
inspect as per attached Dimension

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

22 11. 10. 2710

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

22 11. 10. 2710

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Required Date:	10/28/2011	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 SL 11-10-29 0.00							
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				10	11-10-31		
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo	0.00 0.00							

M117745

START TIME: 12:15
FINISH TIME: 12:45
OVEN TEMPERATURE: 320°F

10XØ m-f 11/10/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

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Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				10 COUNT	1	94 11/10/31	
170 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00						11/10/31 (10)	
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						11/11/01	

mf 11-11-01

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 03, 2011 9:45:04 AM

Page 1

Work Order ID: 74476



Parent Item: D2661-2



Parent Item Name: Saddle, RH Fwd Aft Out 206


Start Date: 9/30/2011

Required Date: 10/28/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C00.11.01 Removed P/O for Powder Coat - in house process EC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 		Manufactured	No			100	Each	73.0000	1	10			

Saddle Billet, 7075

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT040	8	
72226	8	
MAT44	65	
72226	5	
73769	60	

74680 X 10

and 11/10/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 74476
Description: 206 Saddle, Outboard, Right side	Part Number: D2661-2
Inspection Dwg: D2661 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140	1.133	1.133	1.133	1.133	1.133	1.133	1.133
B	0.100	0.140	1.125	1.125	1.125	1.125	1.125	1.125	1.125
C	1.250	1.270	1.140	1.140	1.140	1.140	1.140	1.140	1.140
D	0.615	0.685	1.685	1.685	1.685	1.685	1.685	1.685	1.685
E	0.240	0.260	1.250	1.250	1.250	1.250	1.250	1.250	1.250
F	1.437	1.467	1.325	1.325	1.325	1.325	1.325	1.325	1.325
G	0.210	0.230	1.225	1.225	1.225	1.225	1.225	1.225	1.225
H	0.100	0.180	1.135	1.135	1.135	1.135	1.135	1.135	1.135
I	2.470	2.510	2.492	2.492	2.492	2.492	2.492	2.492	2.492
J	1.565	1.585	1.580	1.580	1.580	1.580	1.580	1.580	1.580
K	0.235	0.240	1.237	1.237	1.237	1.237	1.237	1.237	1.237
L	0.100	0.120	1.110	1.110	1.110	1.110	1.110	1.110	1.110
M	0.990	1.010	1.997	1.997	1.997	1.997	1.997	1.997	1.997
N	0.510	0.515	1.512	1.512	1.512	1.512	1.512	1.512	1.512
O	5.990	6.010	5.999	5.999	5.999	5.999	5.999	5.999	5.999
P	1.245	1.255	1.250	1.250	1.250	1.250	1.250	1.250	1.250
Q	2.495	2.505	2.500	2.500	2.500	2.500	2.500	2.500	2.500
R	0.313	0.318	1.313	1.313	1.313	1.313	1.313	1.313	1.313
S	0.315	0.322	1.316	1.316	1.316	1.316	1.316	1.316	1.316
T	2.495	2.505	2.500	2.500	2.500	2.500	2.500	2.500	2.500
U	1.357	1.367	1.362	1.362	1.362	1.362	1.362	1.362	1.362
V	0.787	0.807	1.791	1.791	1.791	1.791	1.791	1.791	1.791
W	0.540	0.560	1.556	1.556	1.556	1.556	1.556	1.556	1.556
X	1.674	1.684	1.680	1.680	1.680	1.680	1.680	1.680	1.680
Y	0.257	0.262	1.257	1.257	1.257	1.257	1.257	1.257	1.257
Z	0.912	0.932	1.922	1.922	1.922	1.922	1.922	1.922	1.922
AA	0.490	0.510	1.500	1.500	1.500	1.500	1.500	1.500	1.500
AB	0.178	0.198	1.188	1.188	1.188	1.188	1.188	1.188	1.188
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u> R </u>	Audited by: <u> JL </u>
Date: <u> 11-10-28 </u>	Date: <u> 11-10-29 </u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

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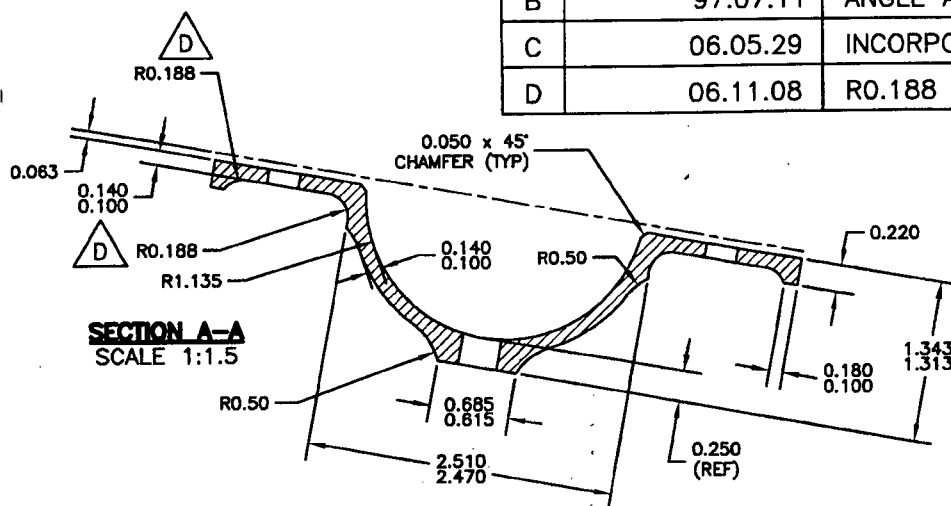
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

DESIGN	<i>AH</i>	DRAWN BY	<i>CB</i>	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED	<i>PH</i>	APPROVED	<i>AH</i>	DRAWING NO.	REV. D
				D2661	SHEET 1 OF 1
DATE	06.11.08			TITLE	SCALE
				SADDLE OUTSIDE	1:3
A	97.03.25	NEW ISSUE			
B	97.07.11	ANGLE AND NOTES ADDED			
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095			
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313			



RELEASED

07.02.12 *AH*
SHOP COPYRETURN TO
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

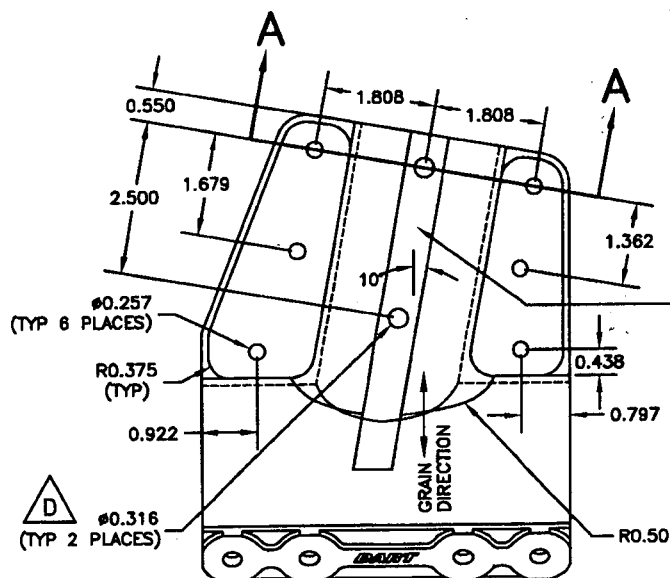
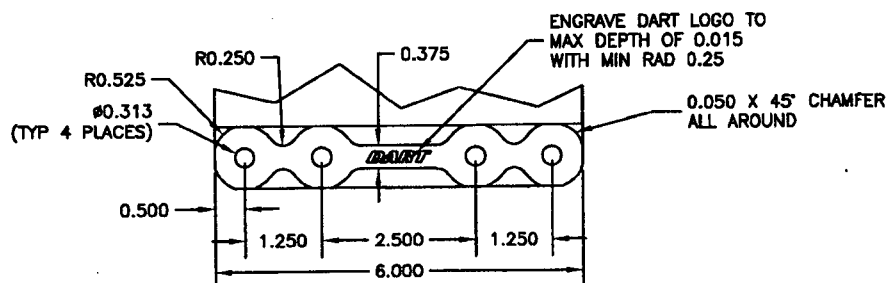
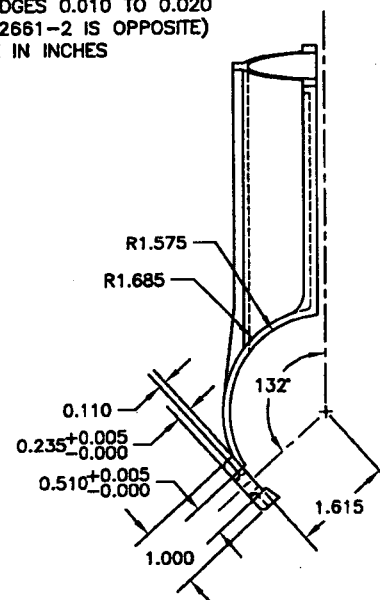
WITHOUT NOTICE

WORK ORDER

NO. 74476 M.C. J
11/10/03

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12) (MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2661-1 SHOWN (D2661-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010**D2661-1 SADDLE OUTSIDE**

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